



for Service Bulletin #168

Immediately Remove from Service



Service Bulletin #168 SJ12E, SJ16E, SJ20E

Mast Weld Reinforcement

***** ⚠ **SAFETY RELATED** ⚠ *****

A failure to comply with this bulletin could result in serious injury or death.

June, 16 2023

Models Affected: SJ12E, SJ16E, SJ20E

Serial Ranges:

- SJ12E: A601000906 through A601005185
- SJ16E: A601000909 through A601005478
- SJ20E: A601000763 through A601005631

Specific Affected Serial Numbers are listed at the end of this bulletin.

Introduction:

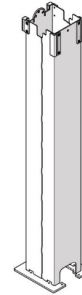
On the identified machines, Skyjack has identified a quality issue with the weld between the mast base plate and mast vertical section. Failure to implement this bulletin may result in cracks developing along the weld between the mast base plate and the mast vertical section, potentially leading to structural failure of the vertical mast causing serious injury or death.

The units listed under "Affected Serial Numbers" **must be immediately removed from service** and have the mast section repaired as soon as possible. Skyjack requires that this bulletin be completed on all affected models with the listed serial numbers.

This bulletin is also available on our website at: www.skyjack.com.

MAST WELD REINFORCEMENT

SJ12 E, SJ16 E, SJ20 E
ANSI/CSA, CE, AS & KC



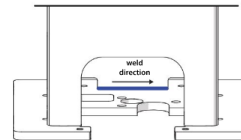
2.2-2 Reinforce the mast weld - SJ12 E

Refer to the overview diagram on page 19.

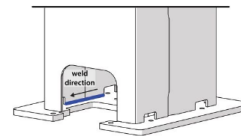
Use E7018 welding rods, ø 3 mm x 350 mm (ø 1/8" x 14") to produce 5 mm (3/16") fillet welds for the following steps.

Clean contamination, foreign matter, and paint from the surfaces to be welded.

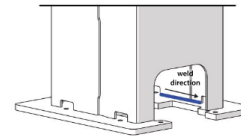
Weld 1: Weld along the inner front face of the mast, between the slots.



Weld 2: Weld along the inner left face of the mast, between the slots.



Weld 3: Weld along the inner right face of the mast, between the slots.



Isometric drawing illustrating weld locations SJ12E



**SJ12E, SJ16E, SJ20E
Check Serial Numbers**